

# Work Order ID 70394

Tuesday, June 07, 2011 8:55:43 AM

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Page 1

Item ID: D2649

Accept

Revision ID:

Item Name: Cross Bolt Spacer

Setup Start

Stop

Start Date: 6/7/2011 Start Qty: 200.00

Required Date: 6/10/2011 Req'd Qty: 200.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-08-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr
D2649	Rev B1

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per folio FA214 on cobra machine.

111678

208

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

111678

208

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

11.6.8

208

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70394**

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Item ID: D2649

Accept



Setup Start



Revision ID:

Stop



Item Name: Cross Bolt Spacer

Start Date: 6/7/2011 Start Qty: 200.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 200.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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125

0.00



Skidtubes

Memo

0.00

Skidtubes

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

208 P BE 11/06/08

130

0.00



Packaging

Identify as per dwg & Stock Location: LG

Memo

0.00

Packaging

\*\*\*STOCK IN SKIDTUBE CELL\*\*\*

208 P BE 11/06/08

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/6 (98)MF  
11-06-08

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 07, 2011 8:55:40 AM

Page 1

Work Order ID: 70394



Parent Item: D2649

Parent Item Name: Cross Bolt Spacer

Start Date: 6/7/2011

Required Date: 6/10/2011

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP F 02.03.26 Added turning on Cobra NG  
added cleaning DD verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.375W.058

Purchased

No

100

f

303.5480

0.2833

59.64211



SA 11/6/18

6061-T6 RD Tube .375 x.058W

Location

Loc Qty

Loc Code

MAT014

303.548

115901

7.9

116920

0.578

117598

295.07

60 RT

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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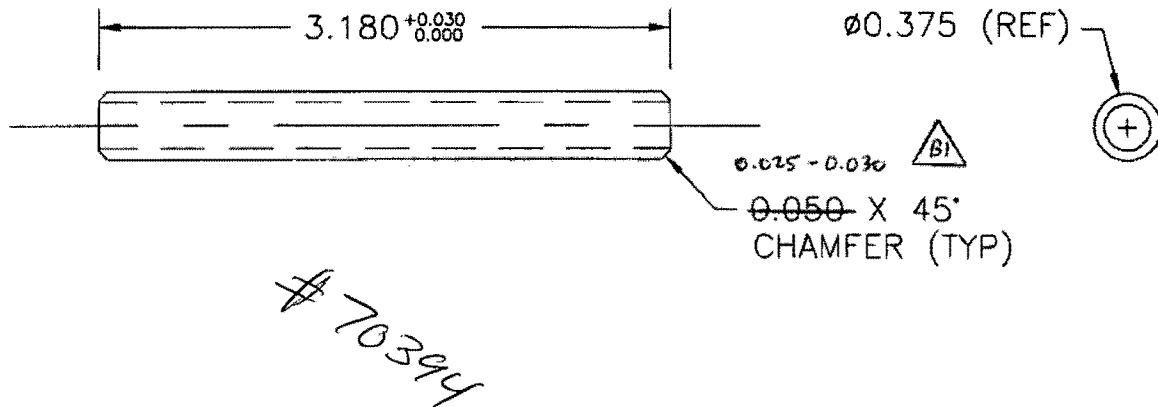
**NOTE:** Date & initial all entries





DESIGN <i>DW</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DW</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
BI	<i># CP</i> 02.06.13	REDUCE CHAMFER PER TSR 1246.	

RELEASED  
98.01.20 DS



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)  
0.375 DIA 0.058 WALL  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

# Dart Aerospace Ltd

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